Date: Wednesday, 1/31/2007 2:47:49 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: HELI UTILITY BASKET LH/RH 350/355
Job Number	: 30527		
Estimate Number	: 10208		
P.O. Number	: N/A	**Part Number**	: D350607043
This Issue	: 1/31/2007 **S.O. No.** : N/A	**Drawing Number**	: D350-607 REV F P7-9
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: F
Previous Run	: 30355	**Material**	: N/A
Written By	:	**Due Date**	: 2/15/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.02.01		
Comment	: Est Rev:E as Per DSI9318 06-01-24 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD350-607-043 CHG003 KS 07.02.05 (1)

Seq. #:	Machine Or Operation:	Description :
2.0	30527A	BASKET LID ASSEMBLY

Comment: Sub-Component BASKET LID ASSEMBLY
D2989-041 B 30527A

Seq. #:	Machine Or Operation:	Description :
3.0	30527B	BASKET LID ASSEMBLY

Comment: Sub-Component BASKET LID ASSEMBLY
D2989-043 B 30527B

Seq. #:	Machine Or Operation:	Description :
4.0	30527C	BASKET BASE ASSEMBLY (350)

Comment: Sub-Component BASKET BASE ASSEMBLY (350)
D2221 B 30527C

Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

Seq. #:	Machine Or Operation:	Description :
6.0	NAS1515H4	Washer

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	NAS1515H4	WASHER	M101428

MF 07-03-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:47:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 30527
Part Number: D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	D2022101	Spacer

Comment: Qty.: 5 Each(s)/Unit Total : 5 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
5	D2022-101	Spacer	B26664

X mF 07-03-06

Seq. #:	Machine Or Operation:	Description :
8.0	D2258200	Weight Placard 200lb

Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2258-200	Label	B28312

mF 07-03-06

Seq. #:	Machine Or Operation:	Description :
9.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2332-041	Prop Ass'y	~~B280~~ B29134

mF. 07-03-06

Seq. #:	Machine Or Operation:	Description :
10.0	D2530	Handle Weldment

Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2530	Handle Weldment	B28997

mF. 07-03-06

Seq. #:	Machine Or Operation:	Description :
11.0	D2535	Spring

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2535	Spring	B28363

mF. 07-03-06

Seq. #:	Machine Or Operation:	Description :
12.0	D2537	Bushing

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2537	Bushing	B29536

mF. 07-03-06

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:47:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 30527
Part Number: D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	D27283	Dart Logo label large

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch		
2	D2728-3	Label	B22553	mF.	07-03-06

Seq. #:	Machine Or Operation:	Description :
14.0	D2931	Bumper

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch		
2	D2931	Bumper	B21139	mF.	07-03-06

Seq. #:	Machine Or Operation:	Description :
15.0	AN316A	Bolt

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch		
2	AN3-16A	Bolt	M101884	mF.	07-03-06

Seq. #:	Machine Or Operation:	Description :
16.0	AN413A	Bolt

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch		
2	AN4-13A	Bolt	M103363	mF.	07-03-06

Seq. #:	Machine Or Operation:	Description :
17.0	AN422A	Bolt

Comment: Qty.: 7 Each(s)/Unit Total : 7 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch		
7	AN4-22A	Bolt	M100771	mF.	07-03-06

Seq. #:	Machine Or Operation:	Description :
18.0	AN517A	Bolt

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch		
4	AN5-17A	Bolt	M102140	mF.	07-03-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:47:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 30527 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD8	Washer

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M102842 mF. 07-03-06

20.0	AN960JD416	Washer

Comment: Qty.: 14 Each(s)/Unit Total : 14 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
14 AN960JD416 Washer M10 3338. mF. 07-03-06

21.0	AN960JD416L	Washer

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M101237 mF. 07-03-06.

22.0	AN960JD516	Washer

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M102929. mF. 07-03-06

23.0	AN9704	Washer

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M102929. mF. 07-03-06

24.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS20600AD4W3 Rivet M14393 mF. 07-03-06

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:47:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 30527
Part Number: D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	MS21042L3	Nut

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M102217
MF. 07-03-06

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L4	Nut

Comment: Qty.: 9 Each(s)/Unit Total : 9 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
9 MS21042L4 Nut (or -4) M103349
MF. 07-03-06

Seq. #:	Machine Or Operation:	Description :
27.0	MS21042L5	Nut

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) M100564
MF. 07-03-06

Seq. #:	Machine Or Operation:	Description :
28.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: M103497
Exp Date: 10/2007.
MF- 07-03-06
MF. 07-03-06

Seq. #:	Machine Or Operation:	Description :
29.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
07/03/06

Seq. #:	Machine Or Operation:	Description :
30.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit
7/3/7

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:47:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 30527
Part Number: D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	D22301	Mounting Lug

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-1	Lug	B30155 ✓

Seq. #:	Machine Or Operation:	Description :
32.0	D22303	Mounting Lug

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-3	Clamp	B29601 ✓

Seq. #:	Machine Or Operation:	Description :
33.0	D23241	Strut Assembly

Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	*D2324-1	Strut Ass'y	B28914 ✓

Seq. #:	Machine Or Operation:	Description :
34.0	D2856400	Abrasion Strip

Comment: Qty.: 1 f(s)/Unit Total : 1 f(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2856-400-720	Abrasion Strip	B28850 ✓

Seq. #:	Machine Or Operation:	Description :
35.0	AN412A	Bolt

Comment: Qty.: 5 Each(s)/Unit Total : 5 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
5	AN4-12A	Bolt	M102929 ✓

Seq. #:	Machine Or Operation:	Description :
36.0	AN413A	Bolt

Comment: Qty.: 8 Each(s)/Unit Total : 8 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-13A	Bolt	M103363 ✓

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/03/08

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:47:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 30527
Part Number: D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
37.0	AN960JD416	Washer

Comment: Qty.: 26 Each(s)/Unit Total : 26 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
26 AN960JD416 Washer M10333F

Seq. #:	Machine Or Operation:	Description :
38.0	MS21042L4	Nut

Comment: Qty.: 13 Each(s)/Unit Total : 13 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
13 MS21042L4 Nut (or -4) M17997

7/3/?

Seq. #:	Machine Or Operation:	Description :
39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

Seq. #:	Machine Or Operation:	Description :
40.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-607-043
Location: NEVE

7/3/?

Seq. #:	Machine Or Operation:	Description :
41.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion

07.03.08

Dart Aerospace Ltd

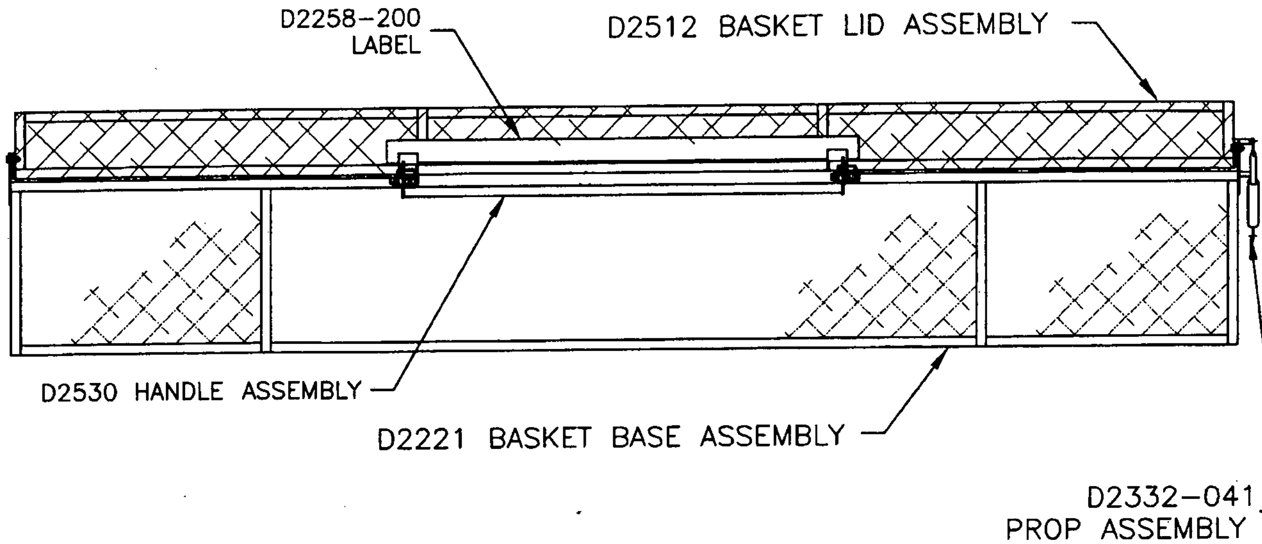
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

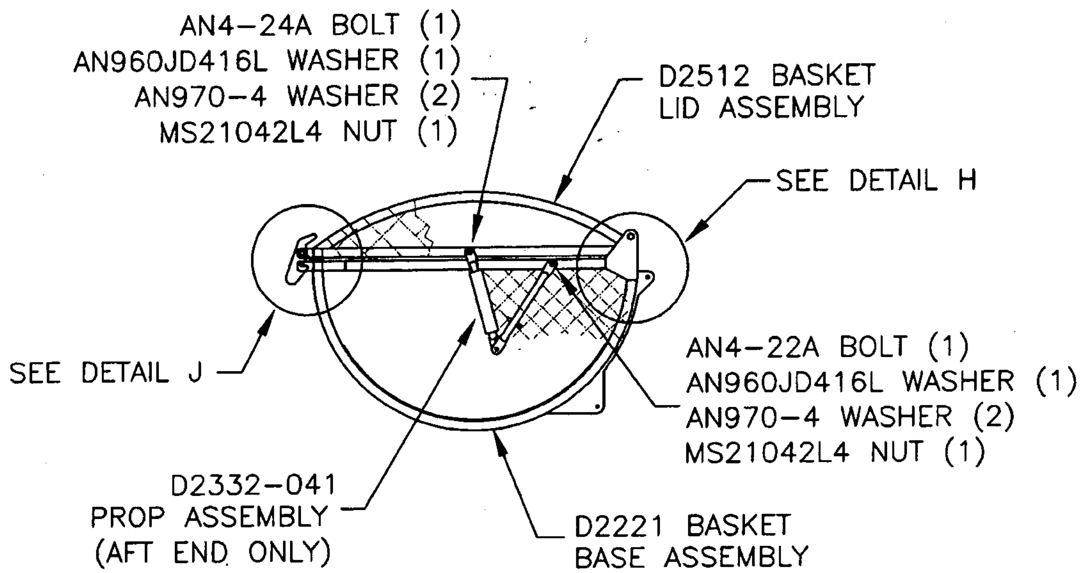
Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

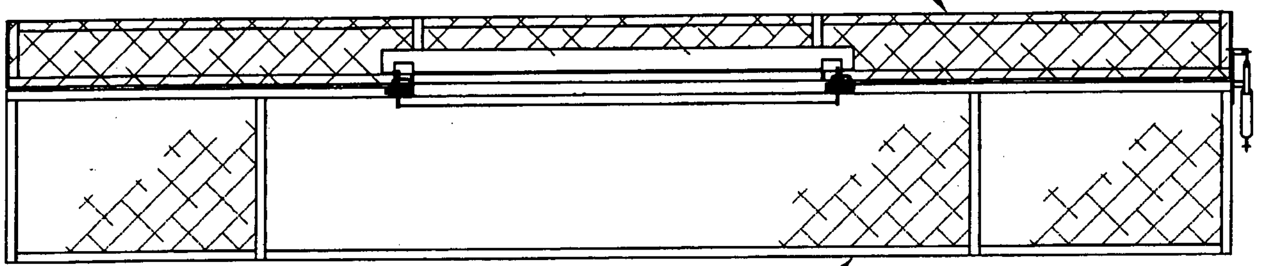
NOTE: Date & initial all entries

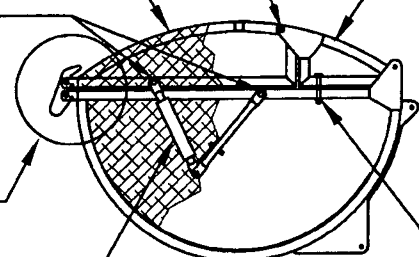




PROP ARM DETAIL
(VIEW C-C)

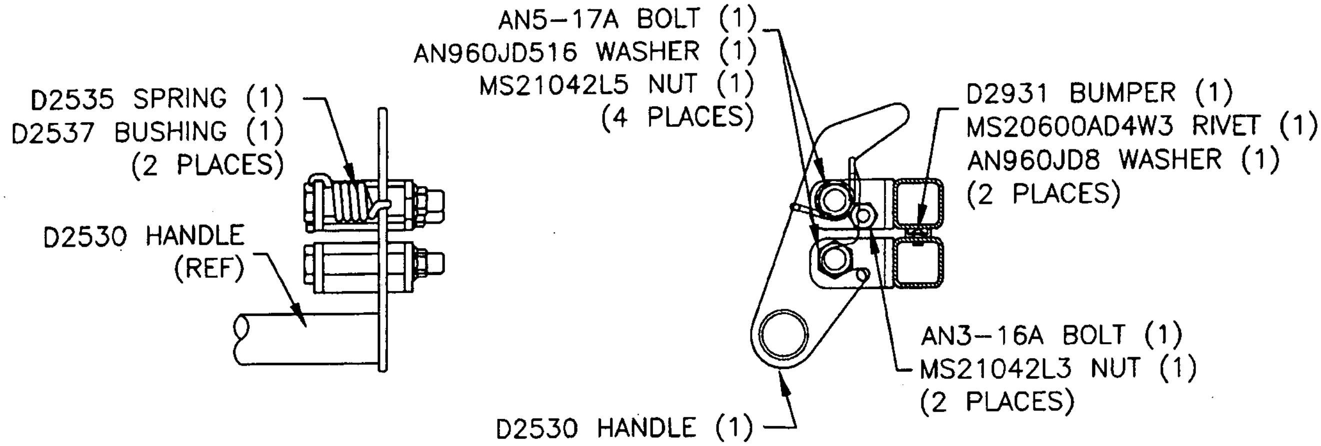
Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)





PROP ARM DETAIL
VIEW C-C

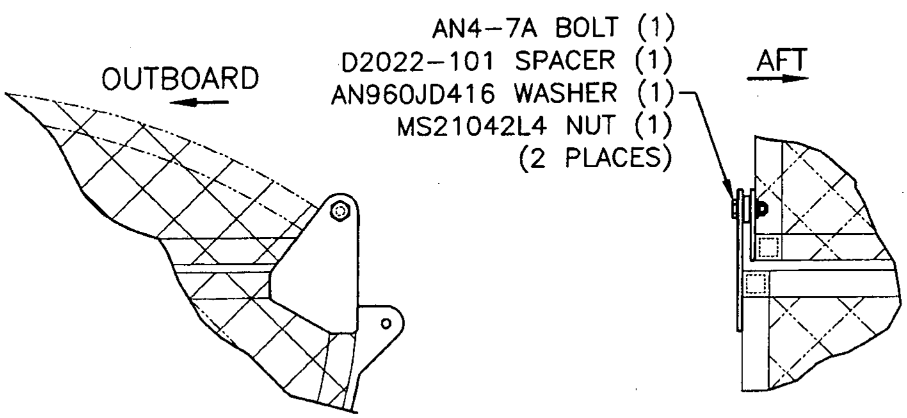
Figure 5– Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)



SPRING DETAIL

LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

Figure 6 – Basket Replacement Parts

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

DART SERVICE INSTRUCTION

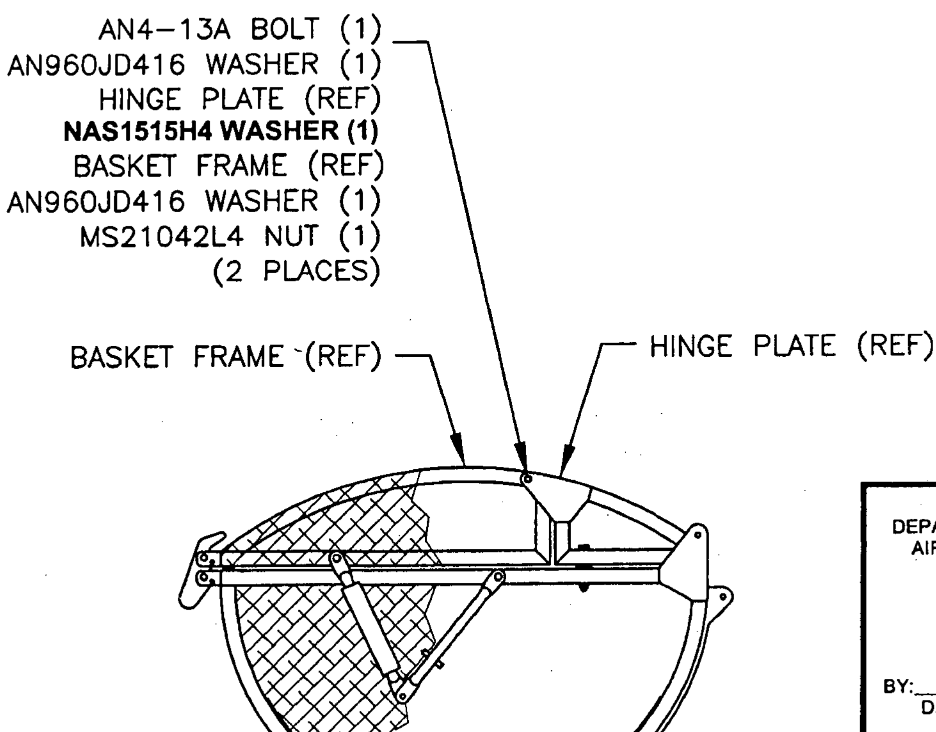
TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047** *Heli-Utility-Basket*.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 06.01.06

CERT. NO. SH94-14

ISSUE NO. 4

SHOP COPY — UNCONTROLLED COPY — SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 30527

Date: Wednesday, 1/31/2007 2:48:02 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 30527A		
Estimate Number	: 10206		
P.O. Number	: N/A	Part Number	: D2989041
This Issue	: 1/31/2007 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 30355A	Material	: N/A
Written By	:	Due Date	: 2/15/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.02.01		
Comment	: Est Rev:I Removed D2989-043 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31663	Basket Hoop

Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick:
Qty.(1) D3166-3 Batch: B30144 PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
2.0	D2581	Mounting Bracket

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D2581	Mounting Brackets	B30003

PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
3.0	D23273	Spacer Bushing

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D2327-3	Bushing	B28597

PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
4.0	D2506	Placard

Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D2506	Label Plate	B27217

PD 07-0220 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET LID ASSEMBLY

Job Number: 30527A **Part Number:** D2989041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 15 sf(s)/Unit Total : 15 sf(s)
Pick:
Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal M103409 PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
6.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 32 f(s)/Unit Total : 32 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: M102765 PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989Identify as D2989-041 PD 07-02-28 (1)

Seq. #:	Machine Or Operation:	Description :
8.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION AA 07/03/01 (1)

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP AA 07/03/01 (1)

Seq. #:	Machine Or Operation:	Description :
10.0	POWDER COATING	POWDER COATING

M103141

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

GJ / M-R 07-03-05 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/03/08

QA: N/C Closed: ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 1/31/2007 2:48:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** BASKET LID ASSEMBLY

Job Number: 30527A | **Part Number:** D2989041

Job Number:

Seq. #:	Machine Or Operation:	Description :
	2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4 Spray Paint Black: M102615 Wing Walk: M 103480	① 07/03/06
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: Inspect Powder Coat and Wing Walk	mf 07-03-06 ①
12.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	① 07/03/08

Job Completion

07-03-08

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2989 REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY SCALE NTS

A	00.10.27	NEW ISSUE
B	05.06.07	ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS

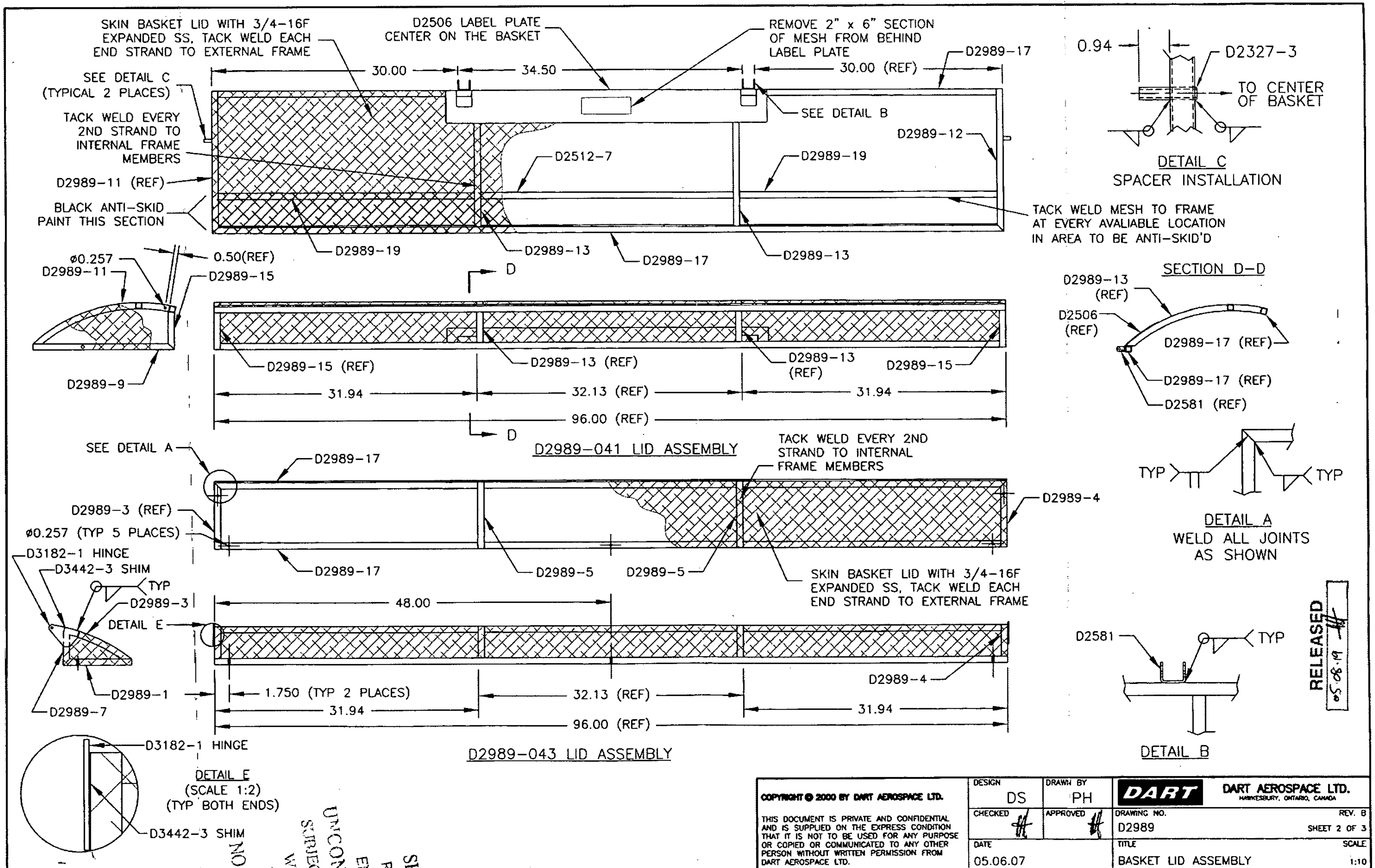
RELEASED 05.08.19

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		**D2989-041**	**BASKET LID ASSEMBLY (OUTSIDE)**
	X	**D2989-043**	**BASKET LID ASSEMBLY (INSIDE)**
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
D2506 LABEL PLATE CENTER ON THE BASKET
REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE
D2989-17
30.00
34.50
30.00 (REF)
SEE DETAIL C (TYPICAL 2 PLACES)
SEE DETAIL B
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
D2989-12
D2512-7
D2989-19
D2989-11 (REF)
BLACK ANTI-SKID PAINT THIS SECTION
TACK WELD MESH TO FRAME AT EVERY AVALIABLE LOCATION IN AREA TO BE ANTI-SKID'D
D2989-19
D2989-13
D2989-17
D2989-13
0.94
D2327-3
TO CENTER OF BASKET
DETAIL C
SPACER INSTALLATION
⌀0.257
D2989-11
0.50(REF)
D2989-15
D
D2989-9
D2989-15 (REF)
D2989-13 (REF)
D2989-13 (REF)
D2989-15
31.94
32.13 (REF)
31.94
96.00 (REF)
D
D2989-041 LID ASSEMBLY
SECTION D-D
D2989-13 (REF)
D2506 (REF)
D2989-17 (REF)
D2989-17 (REF)
D2581 (REF)
SEE DETAIL A
D2989-17
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
D2989-4
D2989-3 (REF)
⌀0.257 (TYP 5 PLACES)
D2989-17
D2989-5
D2989-5
SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
TYP
TYP
DETAIL A
WELD ALL JOINTS AS SHOWN
D3182-1 HINGE
D3442-3 SHIM
TYP
D2989-3
DETAIL E
48.00
D2989-1
D2989-7
1.750 (TYP 2 PLACES)
31.94
32.13 (REF)
31.94
96.00 (REF)
D2989-4
D2581
TYP
DETAIL B
D2989-043 LID ASSEMBLY
D3182-1 HINGE
DETAIL E
(SCALE 1:2)
(TYP BOTH ENDS)
D3442-3 SHIM
RELEASED
05.08.19
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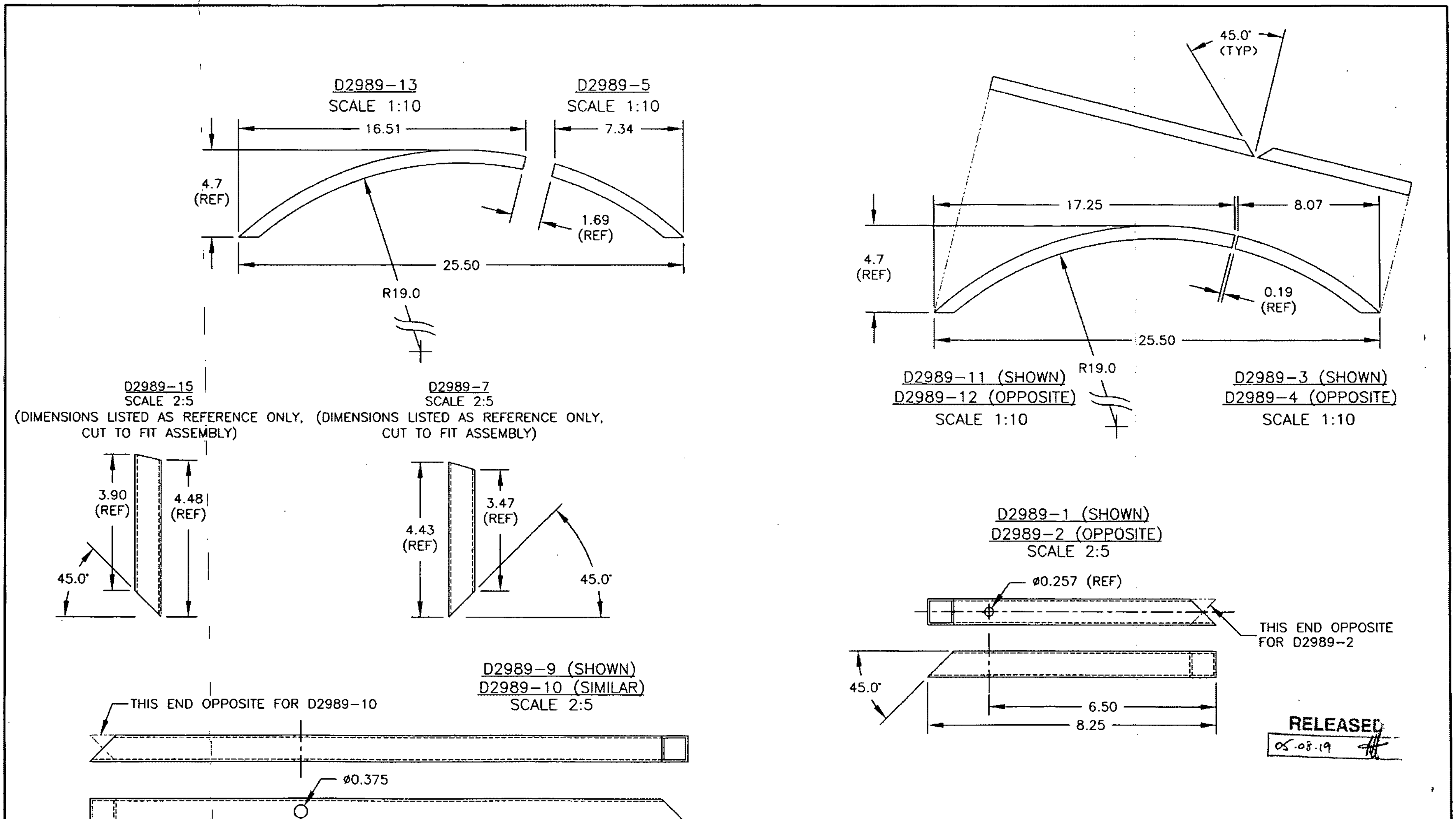
DESIGN DS
DRAWN BY PH
CHECKED
APPROVED
DATE 05.06.07
DART
DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2989
REV. B
SHEET 2 OF 3
TITLE BASKET LID ASSEMBLY
SCALE 1:10



DESIGN	DRAWN BY
DS	PH
CHECKED	APPROVED
DATE 05.06.07	

DART — DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. B
D2989	SHEET 3 OF 3
TITLE	SCALE
BASKET LID ASSEMBLY	1:10

Date: Wednesday, 1/31/2007 2:48:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 30527B		
Estimate Number	: 10207		
P.O. Number	: N/A	Part Number	: D2989043
This Issue	: 1/31/2007 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 30355B	Material	: N/A
Written By	:	Due Date	: 2/15/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.02.01		
Comment	: Est Rev: Removed D2989-041 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31821	Hinge

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:
Qty Part number Description Batch
2 D3182-1 Hinge B30145

PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
2.0	D34423	Shim

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:
Qty Part number Description Batch
2 D3442-3 Shim B26740

PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
3.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 8 sf(s)/Unit Total : 8 sf(s)
Pick:
Qty Part number Description Batch
8sf M304EX0.75-16F Expanded Metal M103409

PD 07-02-20 (1)

Seq. #:	Machine Or Operation:	Description :
4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 18 f(s)/Unit Total : 18 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: H102765

PD 07-02-20 (1)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/03/08

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET LID ASSEMBLY

Job Number: 30527B
Part Number: D2989043

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989
Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

D 07-02-28 (1)

Seq. #:	Machine Or Operation:	Description :
6.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/03/01 (1)

Seq. #:	Machine Or Operation:	Description :
7.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK 07/03/01 (1)

Seq. #:	Machine Or Operation:	Description :
8.0	POWDER COATING	POWDER COATING

Comment: POWDER COATING M 103/4/

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

07-03-05 (1)

Seq. #:	Machine Or Operation:	Description :
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: Inspect Powder Coat MF. 07-03-06 (1)

Seq. #:	Machine Or Operation:	Description :
10.0	QC21	FINAL INSPECTION/W/O RELEASE

(1)

Comment: FINAL INSPECTION/W/O RELEASE 07/03/08

Job Completion

U 07-03-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS

A	00.10.27	NEW ISSUE
B	05.06.07	ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS

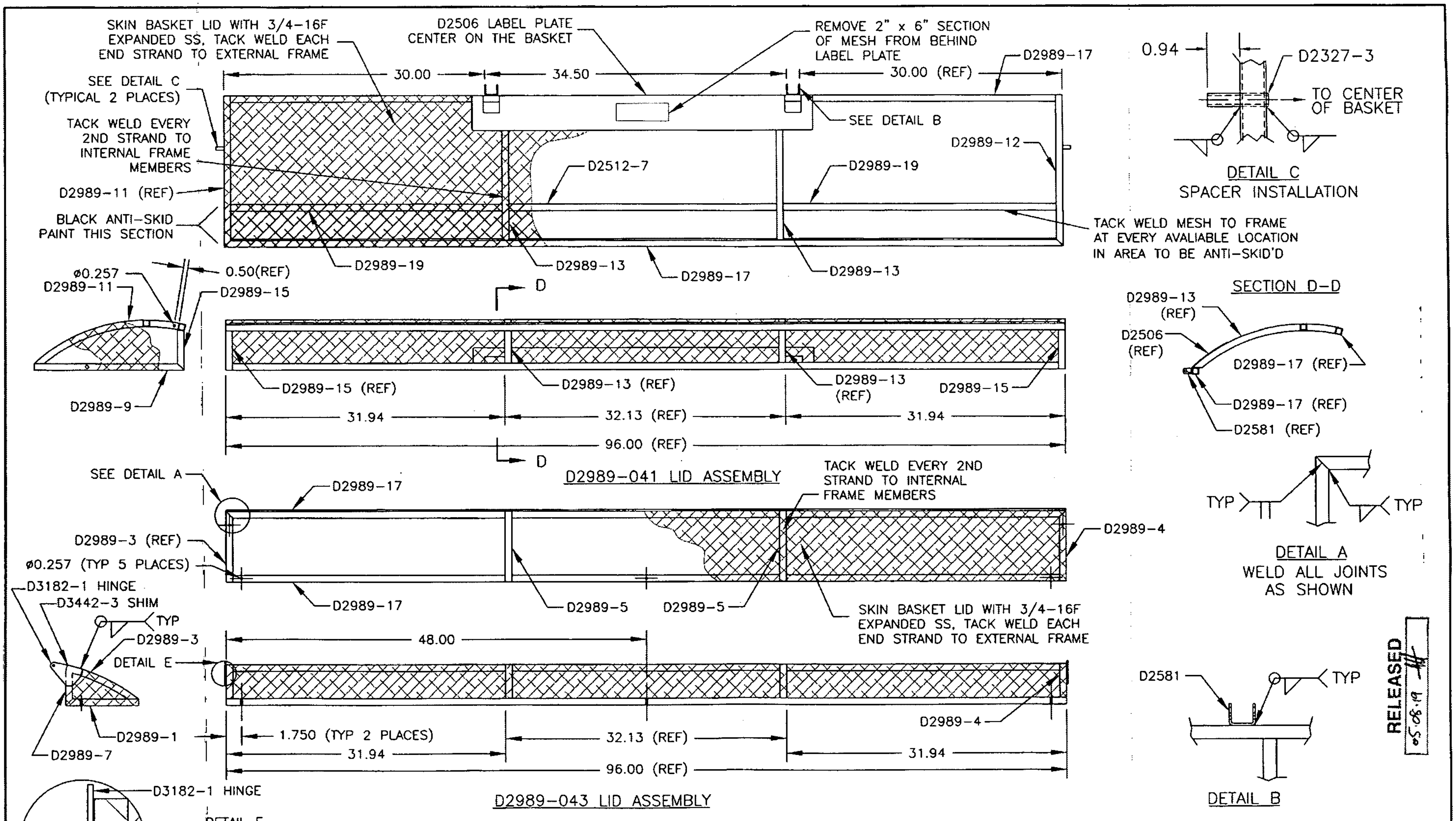
RELEASED 05.08.19

PARTS LIST:

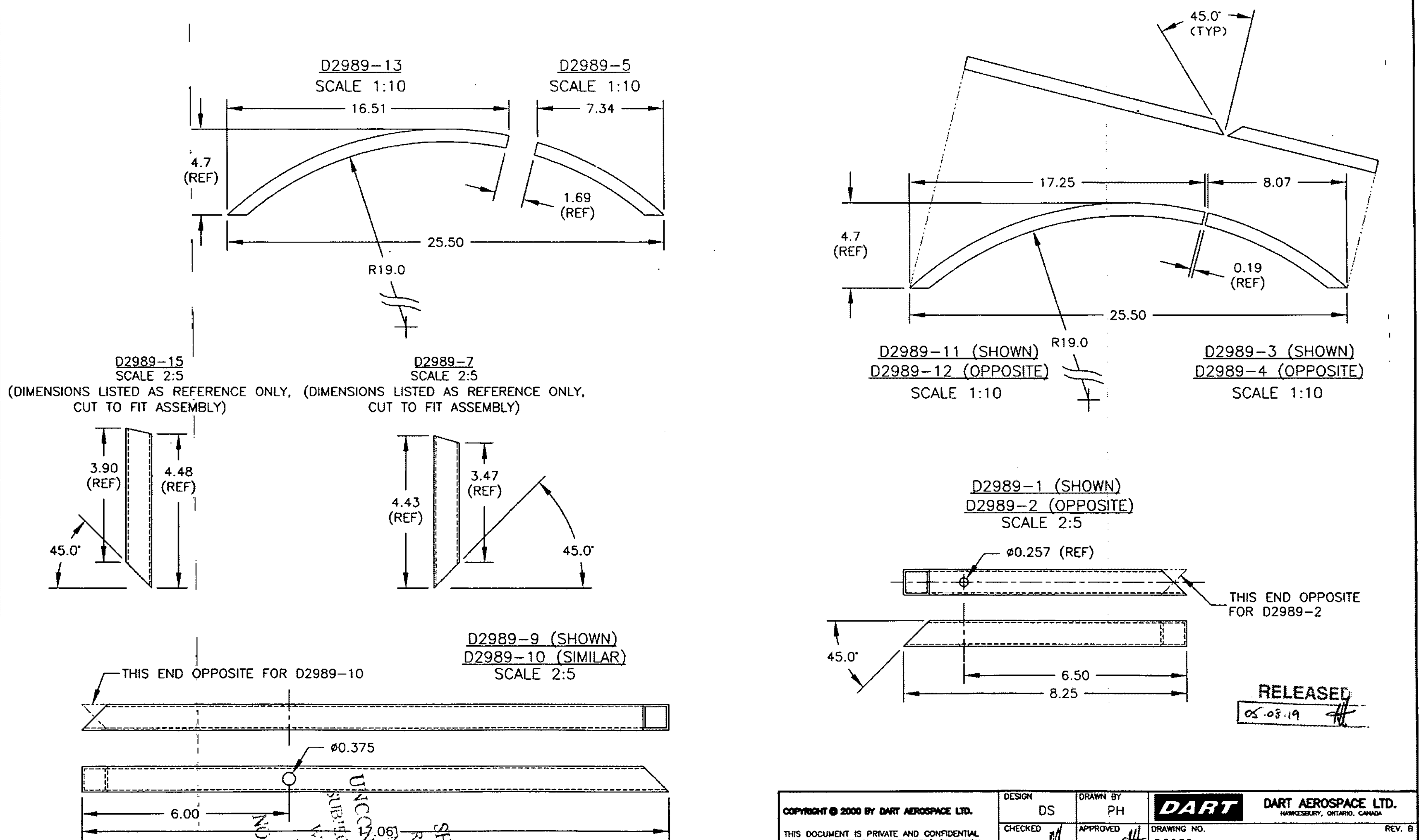
Qty -041	Qty -043	Part Number	Description
X		**D2989-041**	**BASKET LID ASSEMBLY (OUTSIDE)**
	X	**D2989-043**	**BASKET LID ASSEMBLY (INSIDE)**
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2989 — REV. B — SHEET 2 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY — SCALE 1:10



DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2989 — REV. B — SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY — SCALE 1:10

Date: Wednesday, 1/31/2007 2:48:29 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 30527C		
Estimate Number	: 10189		
P.O. Number	: N/A	Part Number	: D2221
This Issue	: 1/31/2007 S.O. No. : N/A	Drawing Number	: D2221/D2235
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F/B1
Previous Run	: 30526A	Material	: N/A
Written By	:	Due Date	: 2/15/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.02.01		
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	B29610-22 B30560-22

PD 07-02-20 ①

Seq. #:	Machine Or Operation:	Description :
2.0	D22323	Basket Hinge

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	B29132

PD 07-2-20 - ①

Seq. #:	Machine Or Operation:	Description :
3.0	D2325	Support Gusset (350 Bask

Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	B29133

PD 07-02-20 ①

Seq. #:	Machine Or Operation:	Description :
4.0	D23273	Spacer Bushing

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B28597

PD 07-02-20 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:48:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** BASKET BASE ASSEMBLY (350)

Job Number: 30527C | **Part Number:** D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D2581	Mounting Bracket

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:
Qty Part Number Description Batch
2 D2581 Mounting Bracket B30003 PD 07-02-20 (1)

6.0	D34421	Shim

Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)
Pick:
Qty Part Number Description Batch
2 D3442-1 Shim B28322
PD 07-02-20 (1)

7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 42 sf(s)/Unit Total : 42 sf(s)
Pick:
Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal M103409 PD 07-02-20 (1)

8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 29 f(s)/Unit Total : 29 f(s)
Pick:
28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M102765
PD 07-02-20 (1)

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required PD 07-02-23 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes $\boxed{\text{No}}$ **DQA:** KD **Date:** 07/03/08

QA: N/C Closed: ______ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:48:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 30527C
Part Number: D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC9	VISUAL WELDING INSPECTION
Comment:	VISUAL WELDING INSPECTION	07/03/01
11.0	QC6	DIMENSIONAL CHECK
Comment:	DIMENSIONAL CHECK	07/03/01
12.0	POWDER COATING M10314	POWDER COATING
Comment:	POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	07-02-05 (1)
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment:	INSPECT POWDER COAT/CHEMICAL CONVERSION	mr. 07-03-06 (1)
14.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment:	FINAL INSPECTION/W/O RELEASE	(1) 07/03/08

Job Completion

07/03/08

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

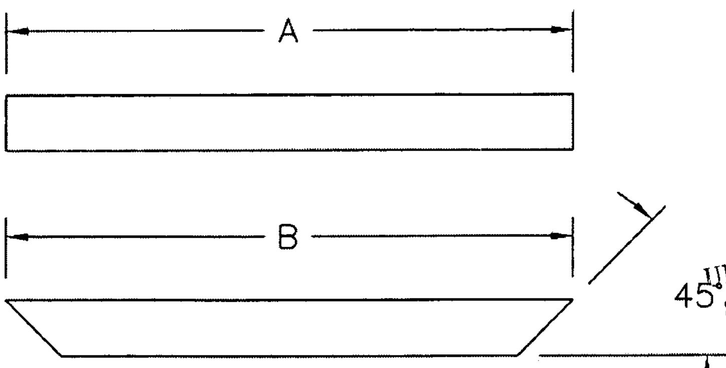
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2221 REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

RELEASED
05.08.19

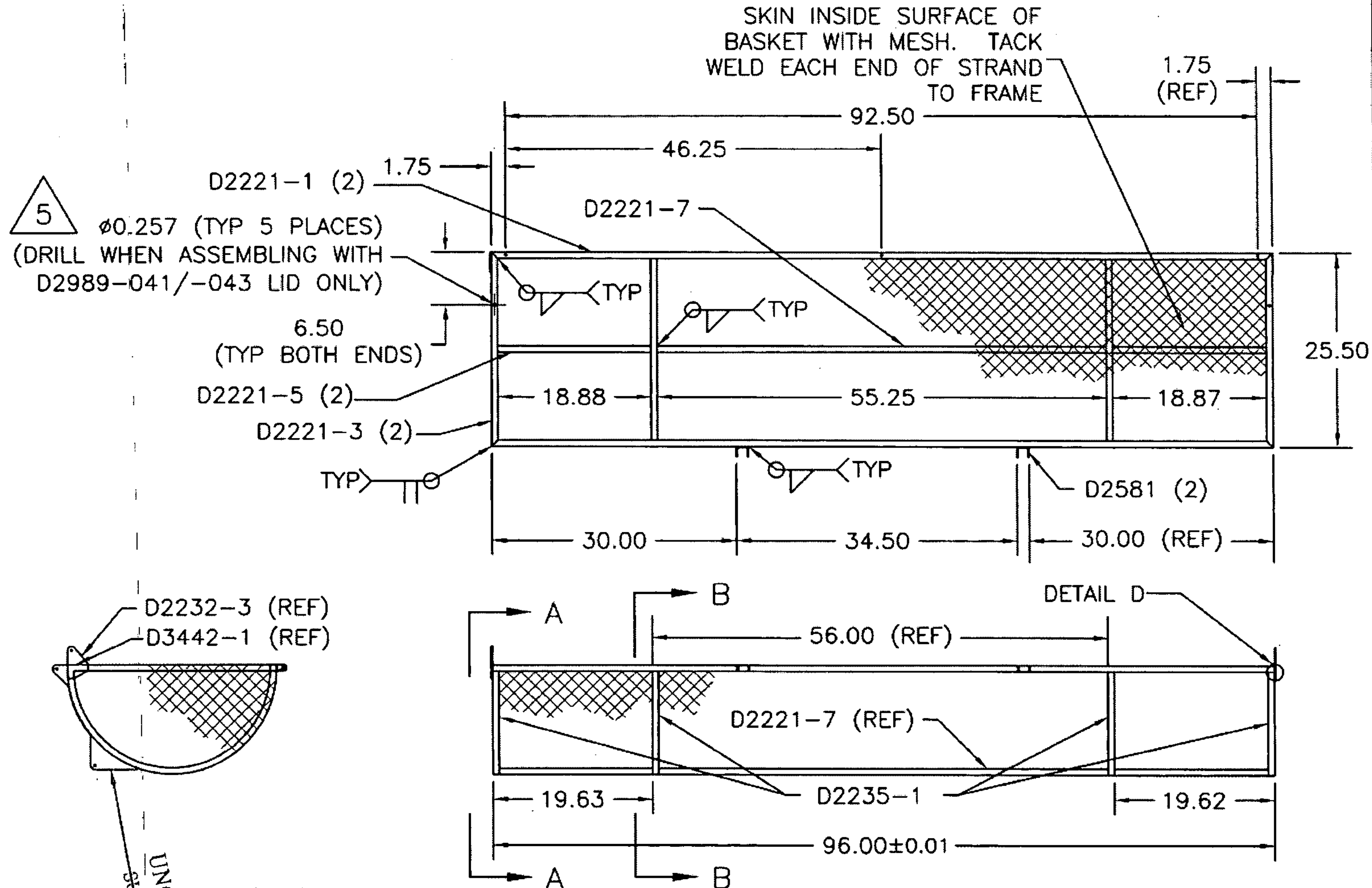
PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

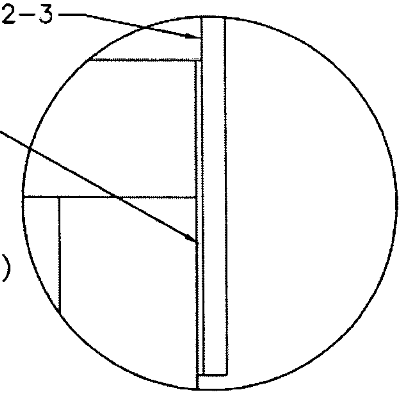
PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	———	96.00	RIB
D2221-3	2	———	25.50	RIB
D2221-5	2	18.88	———	RIB
D2221-7	1	55.25	———	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID





DETAIL D
(SCALE 1:1)
(TYP BOTH ENDS)

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WORK ORDER NO. 30527C

RELEASED 05.08.19

D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

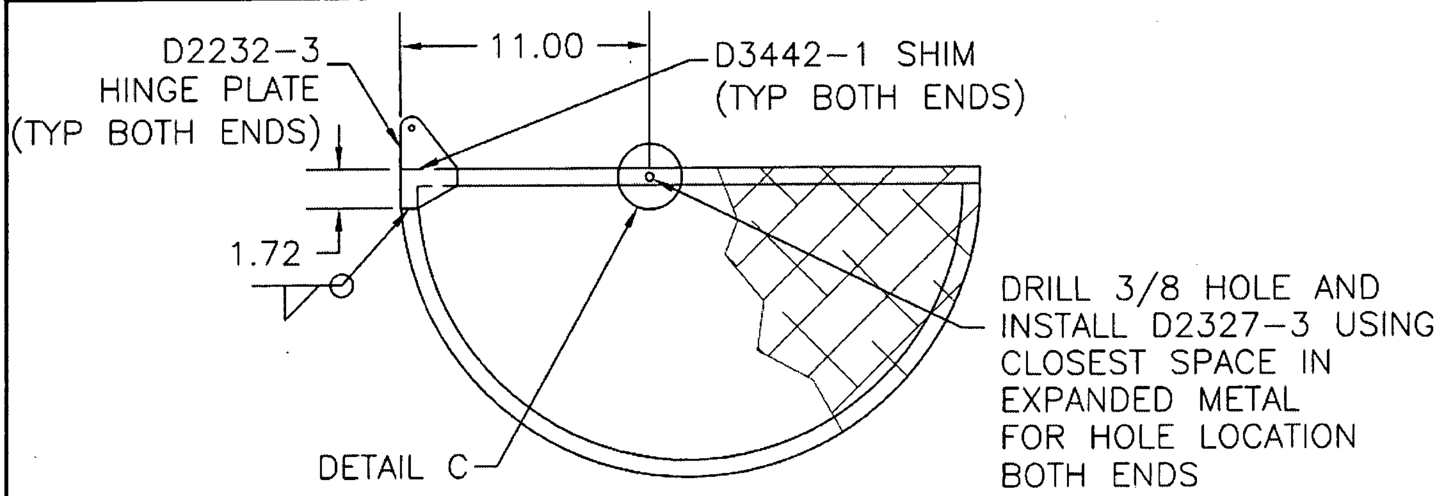
DESIGN	DRAWN BY
BW	PH
CHECKED	APPROVED
DATE 05.06.07	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

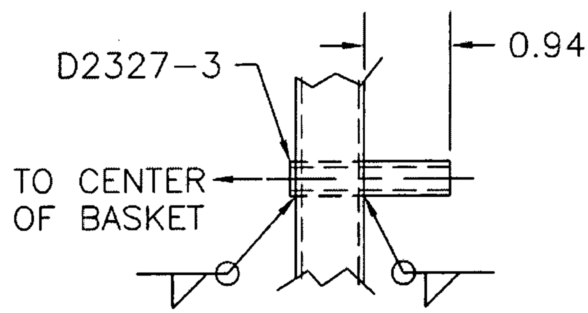
DRAWING NO. D2221
REV. F
SHEET 2 OF 3
TITLE: BASKET BASE ASSEMBLY (350)
SCALE 1:20

DART

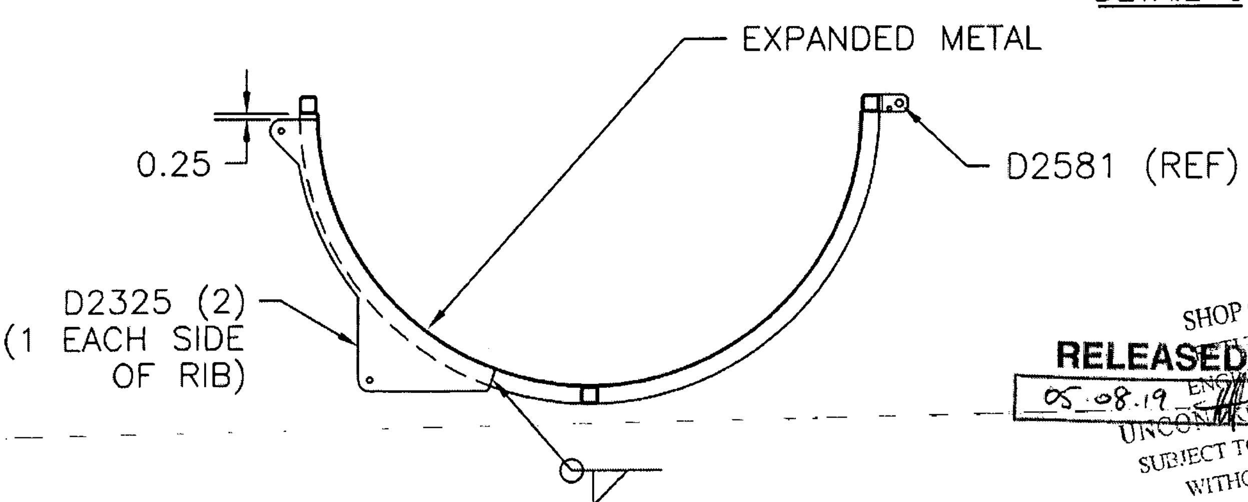
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	PH		
CHECKED	APPROVED	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A-A SAME BOTH END RIBS

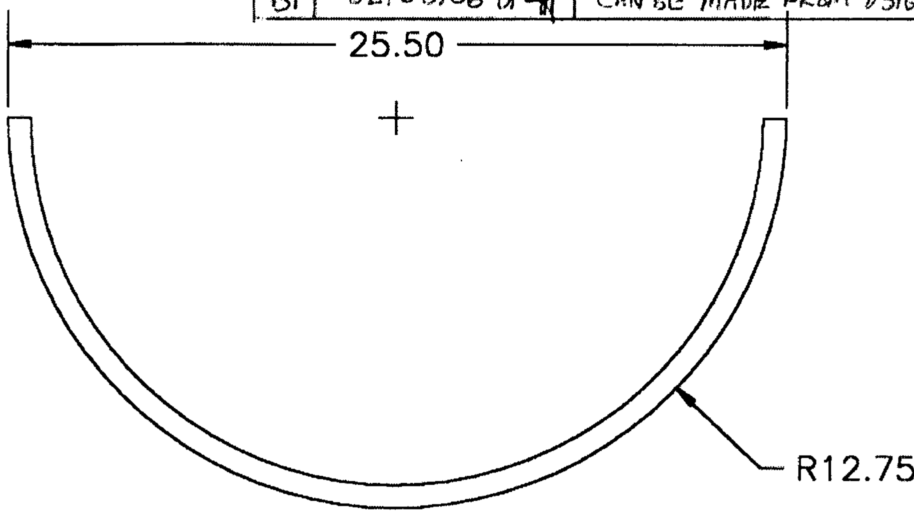


DETAIL C

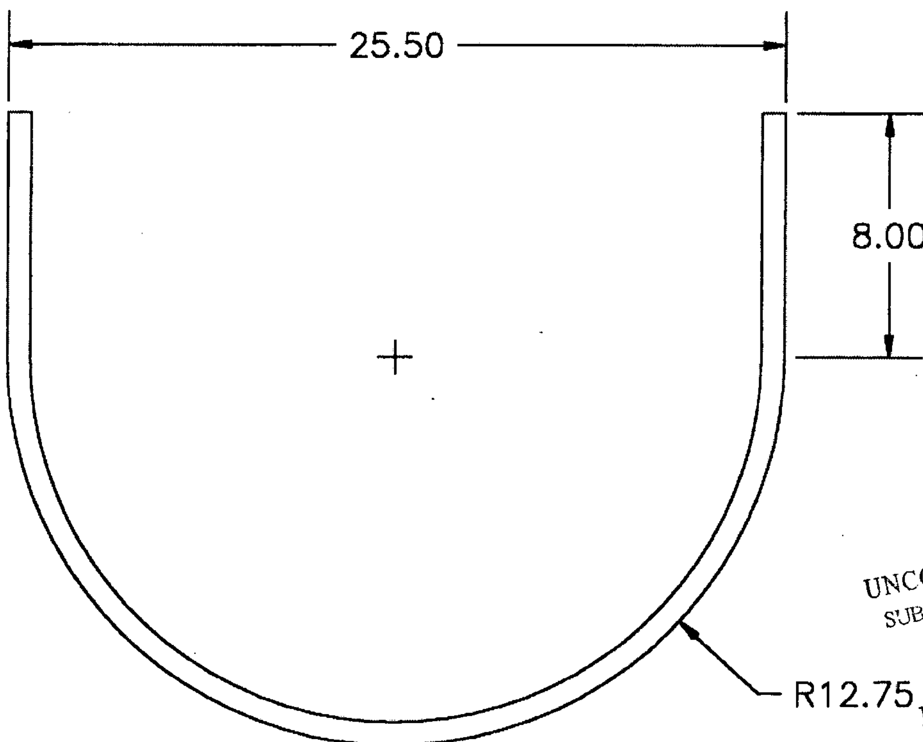


SECTION B-B SAME BOTH CENTER RIBS

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	B WILLIAMS	
CHECKED	APPROVED	DRAWING NO. D2235 — REV. B — SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS — SCALE
B1	02.08.06	CAN BE MADE FROM D3166-1



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 (B1)

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.